Work Order ID 67254

BLUE

Monday, March 14, 2011 10:47:19 AM

Item ID: D2933-2 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle RH In, 206

Start Date: 3/14/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 3/25/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/03/14 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2933	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00				4	ϕ		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number. ☐1-Inspect part number and batch number are programmed correctly. ☐2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00				4	ϕ		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120	QC1- Inspect dimensions to dimension sheet	0.00				4	ϕ		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 67254

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Start Date: 3/14/2011 **Start Qty:** 4.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	B.A	11/03/31		4	ϕ		
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				4	BL 11-3-31		
HandFinish	**Memo**	0.00							
Hand Finishing									
155	Spray Painting per QSI005 4.2	0.00				ml	11	04	07 (4)
SprayPaint	**Memo**	0.00							
Spray Painting	Spray Painting: prime grey B: 115967 spray paint delfleet blue B: 115985 clear delfleet B: 117113								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start

Stop

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	~~QC~~ Inspect Part Finish	0.00							
	QC14								
QC	**Memo**	0.00							
Quality Control									
							11-04-08		
170	Identify as per dwg & Stock Location: 421	0.00							
Packaging	**Memo**	0.00							
Packaging									
						11/4/11			
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									
							11/4/12		

11.04.12

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, March 14, 2011 10:47:16 AM

Work Order ID: 67254

Parent Item: D2933-2

Parent Item Name: Saddle RH In, 206

Start Date: 3/14/2011 **Required Date:** 3/25/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC□
IPP Rev:C As per Rev C 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	56.0000	1	4			

Location	Loc Qty	Loc Code
MAT40	56	
64777	36	
66965	20	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

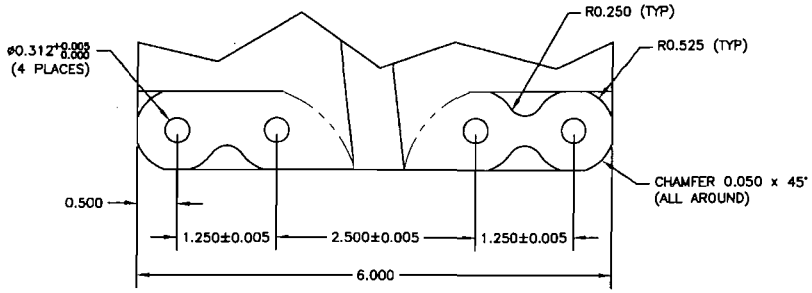
DART AEROSPACE LTD	Work Order:	67254
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

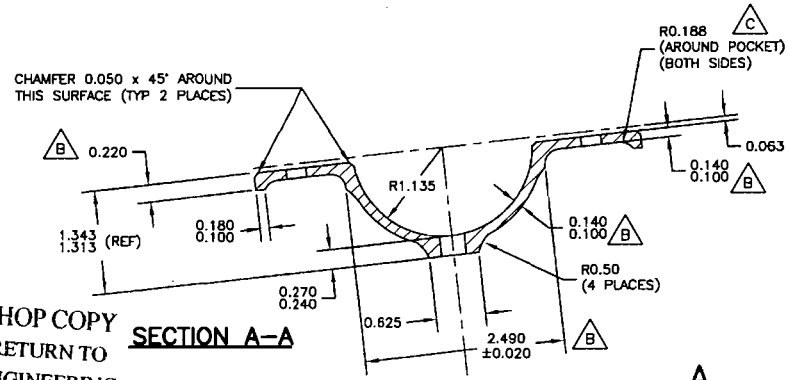
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.132	.128	.127	.128		
B	0.100	0.140		.134	.129	.129	.129		
C	0.100	0.140		.125	.125	.124	.124		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.510	.510	.510		
I	1.572	1.582		1.577	1.574	1.574	1.574		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.236	.238	.237	.237		
N	0.100	0.140		.110	.110	.110	.110		
O	0.540	0.560		.548	.549	.549	.549		
P	0.490	0.510		.492	.493	.492	.493		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.250	.252	.250	.250		
T	0.100	0.180		.130	.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.317	.317	.317	.317		
X	1.125	1.145		1.135	1.137	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.575	1.577	1.575	1.575		
Z	0.178	0.198		.187	.187	.187	.187		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by	M.A
Date:	11/5/29	Date:	11/03/31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



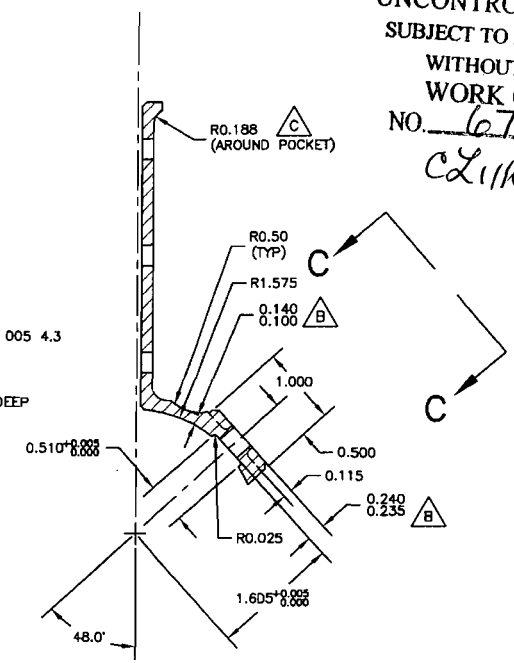
VIEW C–C



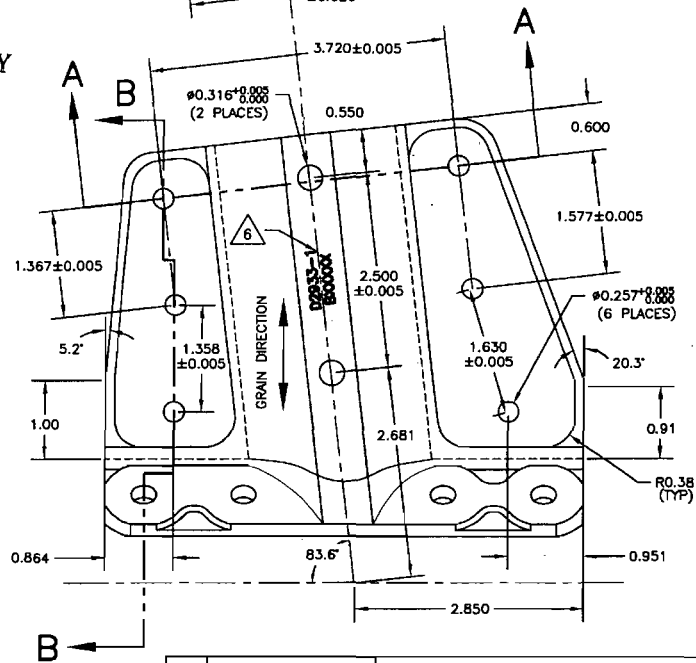
SECTION A–A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67259
CL 11/03/14

D2933–1 LH SADDLE (SHOWN)
D2933–2 RH SADDLE (OPPOSITE)



SECTION B–B



NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

RELEASED
07.02.12

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
	CB		
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2933	SHEET 1 OF 1
DATE		TITLE	SCALE
06.11.09		SADDLE INSIDE	2:3